

Date: Wednesday, 13/02/2008 10:39:16 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT	
Job Number	: 37394		Part Number	: D2565409	
Estimate Number	: 10987		Drawing Number	: D2565 REV E	
P.O. Number	:		Project Number	: N/A	
This Issue	: 13/02/2008 S.O. No. :		Drawing Revision	: E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 20/02/2008 Qty: 1 Um: Each	
Previous Run	: 35175				
Written By	:				
Checked & Approved By	:				
Comment	: Est:A 04.05.10 New Issue KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W  <b>Comment: Qty.: 0.9048 f(s)/Unit Total : 0.9048 f(s)</b> <b>Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall</b> <b>(M304TR0750W049)</b> <b>Batch No: M106015 (2)</b> <b>M105988 (3)</b> <b>M107098 (1)</b>
2.0	BRAKE NC	NC BRAKE  <b>Comment: BRAKE NC</b> <b>Punch as per Dwg D2565 using DT 8313</b> <b>SB 08/02/13 (9)</b>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  <b>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1</b> <b>Deburr</b> <b>E08/02/13 (9)</b>
4.0	QC5	INSPECT WORK TO CURRENT STEP  <b>Comment: INSPECT WORK TO CURRENT STEP</b> <b>08/02/13 (X9)</b>
5.0	POWDER COATING	POWDER COATING  <b>Comment: POWDER COATING</b> <b>Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3</b> <b>Fx 08/02/14 (9)</b>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/02/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



u8



08-07-14

X9

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST259

ST C2810215

9

8.0 QC21

FINAL INSPECTION/W/O RELEASE



9

Comment: FINAL INSPECTION/W/O RELEASE

12/02/08

Job Completion



2008/12/19

9

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

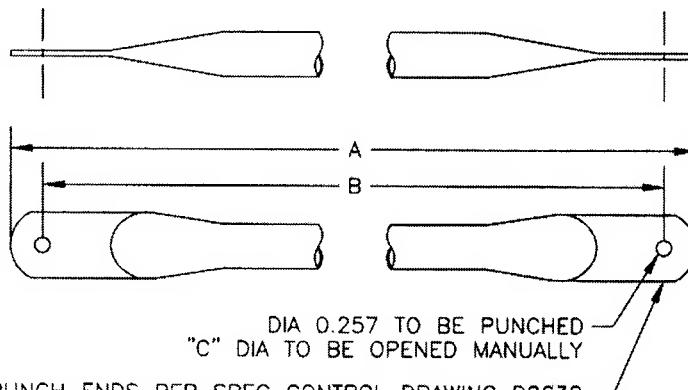
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE		TITLE	SCALE
04.05.05		STRUT	1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED  
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

MO  
37344

102125

104627  
105988  
106132

3/4 X .049